



Dart Aerospace Ltd.
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Canada

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D412-742-043
Job Sheet 168764-A



Part No: D412-742-043

Job Qty: 1 ea

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/22/17

Job Tracking No:

Due Date: 12/8/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3391-043 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg
@ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM IPP
Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517 REV.B DD verified by:EC
IPP REV:G 16.05.02 AS PER DWG REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/17	0.00	0.00	Start Up Container		<i>DMJ 17-12-29</i>
110	HandFinish	1 pcs		12/8/17	0.00	3.50	HandFinish4		<i>JLM 12/29</i>
120	QC	1 pcs		12/8/17	0.00	0.00	QC5		<i>38</i>
125	DC	1 pcs		12/8/17	0.00	0.00	DC		<i>9-89</i>
130	Packaging	1 pcs		12/8/17	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		12/8/17	0.00	0.00	QC21		

Part Op 110 - 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with
Descriptions: saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/-291 _____ Expiry date:
2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped
with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no
sikaflex. A/R Sikaflex-241/-291 _____ Expiry date: 3-Remove "T" pins once sikaflex is dry.
4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon

VERIFY FWD AND AFT SADDLE FIT DURING ASSEMBLY BY: _____ DATE: _____
125 - If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG007
130 - Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation <i>FM 137361-1</i> →	AN3C4A <i>5000533</i>	24	1,093	0	0
	AN3C6A	4	89	0	0
	AN5C7A <i>5002959</i>	10	175	0	0
	D3391-021 <i>501274</i>	1	1	0	0
	D3391-023 <i>5002567</i>	1	0	0	0
	D3391-025 <i>5014251</i>	1	7	0	0
	D4095-041 <i>5164512</i>	1	19	0	0
	D4095-043 <i>5006090</i>	1	13	0	0
	D4095-045 <i>5154875</i>	1	9	0	0
	NAS1149C0332R	28	3,419	0	0
	NAS1149C0532R	10	308	0	0
	<i>5014735</i>				
	<i>5164379</i>				
	<i>13159876</i>				
	<i>FM 138409-1</i> →				

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid-tut Machini Thermoformi Large F		REVISION / PROCESS Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri - Bag Float Comp. PART NO: D412-742-043 Revision: Operation: Change No: CHG007	
Date : _____		Step #: _____		QTY Eff _____			
Description Work Order Deviation							
Root Cause							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Dam	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Ir	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contaminati	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Sho	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐	OTHER :			

S027509

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Approval

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 d Wrong
 Dimensions
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Fit/Function

Misaligned/off center

Turning Sequence